

SHIP TODAY

Work Order ID 56209

February 16, 2010 10:59:36 AM

Page 1

Item ID: D4070-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 2/16/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/16/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4070

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg

Prog rev: Adwg rev: A

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

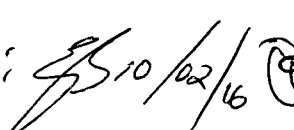
Memo

0.00

Quality Control

Sobelus

(48)

R 10-2-16
Debur:  10/02/16 (49)

R 10-2-16

Work Order ID 56209

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Form as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

150

0.00



Small Fab

Memo

0.00

Small Fab

Assemble rubber cushion as per dwg



Setup Start



Stop



Cust Item ID:

Customer:





[Handwritten signature] 100216 (9)

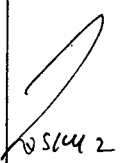

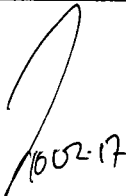
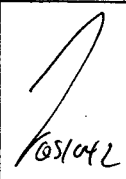
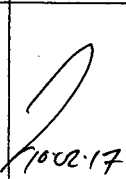
PTO last page

CP 10.02.17 (5) X

[Handwritten signature] 100217

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.02.17	130	- Width of opening is 0.250" INSTEAD OF 0.100 - Acceptable based on test inst install - No powder coat				 10.02.17 451412	 1002-17	

Part No: D4070-1 PAR #: _____ Fault Category: Small Job NCR: Yes ☒ No ☐ DQA: 2 Date: 10.02.17
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>56209</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.02.17	130	4 parts scrap. did not sew correctly, due to being a new part & no tooling as of yet. parts are rush. RC: process.	 1051412	- Scrap & destroyed - New parts: Tooling is going to be made or parts will be subcontracted	 100217	 1002-17	 1051412	 1002-17

NOTE: Date & initial all entries

Work Order ID 56209

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Item ID: D4070-041

Revision ID:

Item Name: Clamp

Start Date: 2/16/10 Start Qty: 2.00

Required Date: 2/16/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

P 10.02.17 (5)

170

0.00

Packaging

Memo

0.00

Packaging

P 10/2/17 (5)

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/17 J

P 10-2-17 (5)

Picklist Print

February 16, 2010 10:59:35 AM

Page 1
T

Work Order ID: 56209



Parent Item: D4070-041



Parent Item Name: Clamp

Start Date: 2/16/10

Required Date: 2/16/10

Comments: IPP rev A 10.02.16 new issue EC verified by: DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2182B		Manufactured	No				f	176.2040	0.3158			
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Rubber Cushion

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	29.886	
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28042	7.33	
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30872	0.33	
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45405	22.226	
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Main Warehouse

ST410	146.318	
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52649	146.318	
-------	---------	--

800

100217

Cut qty 1 at 1.80" long

M304S16GA

Purchased No

100 sf

192.0899 0.0400

2



304/316 Sheet .063

10-2-16

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

MAT	192.0898737	
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106860	8.0295	
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111924	25.1689737	
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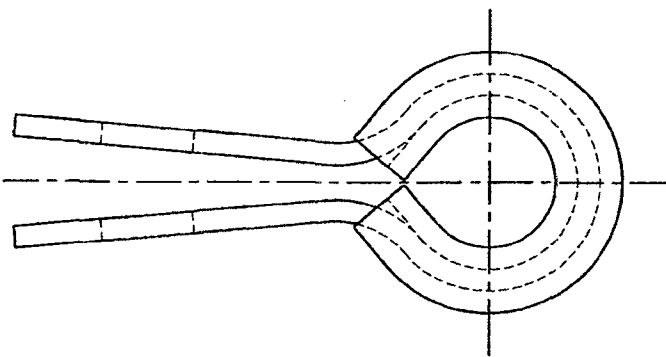
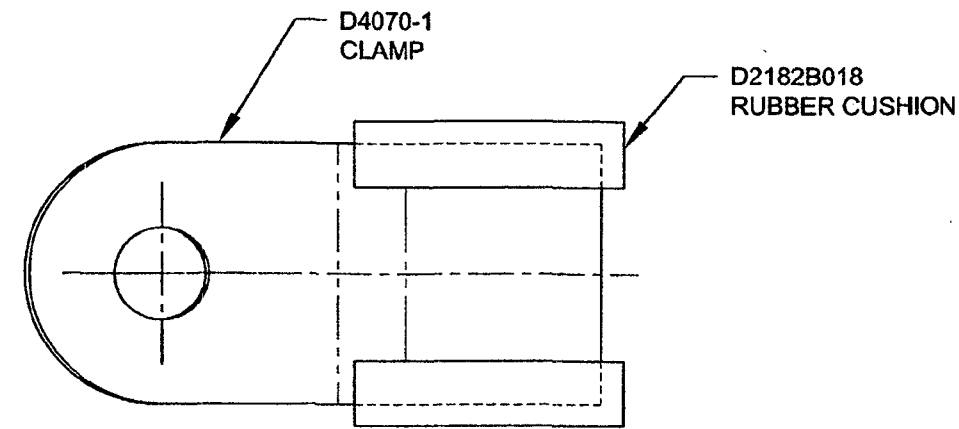
112442	29.8865	
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113295	129.0049	
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113295

9

QTY	PART NUMBER	DESCRIPTION
X	D4070-041	CLAMP
1	D4070-1	CLAMP
1	D2182B018	RUBBER CUSHION



D4070-041 CLAMP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4070-041" USING REMOVABLE TAG
- 7) WEIGHT: 0.05 lbs

RELEASED
2010-02-16
MP

A	NEW ISSUE	CP	10.02.12
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>92</i>	DART AEROSPACE LTD	
DRAWN	<i>92</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4070	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CLAMP	NTS
DATE	10.02.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

D

D

C

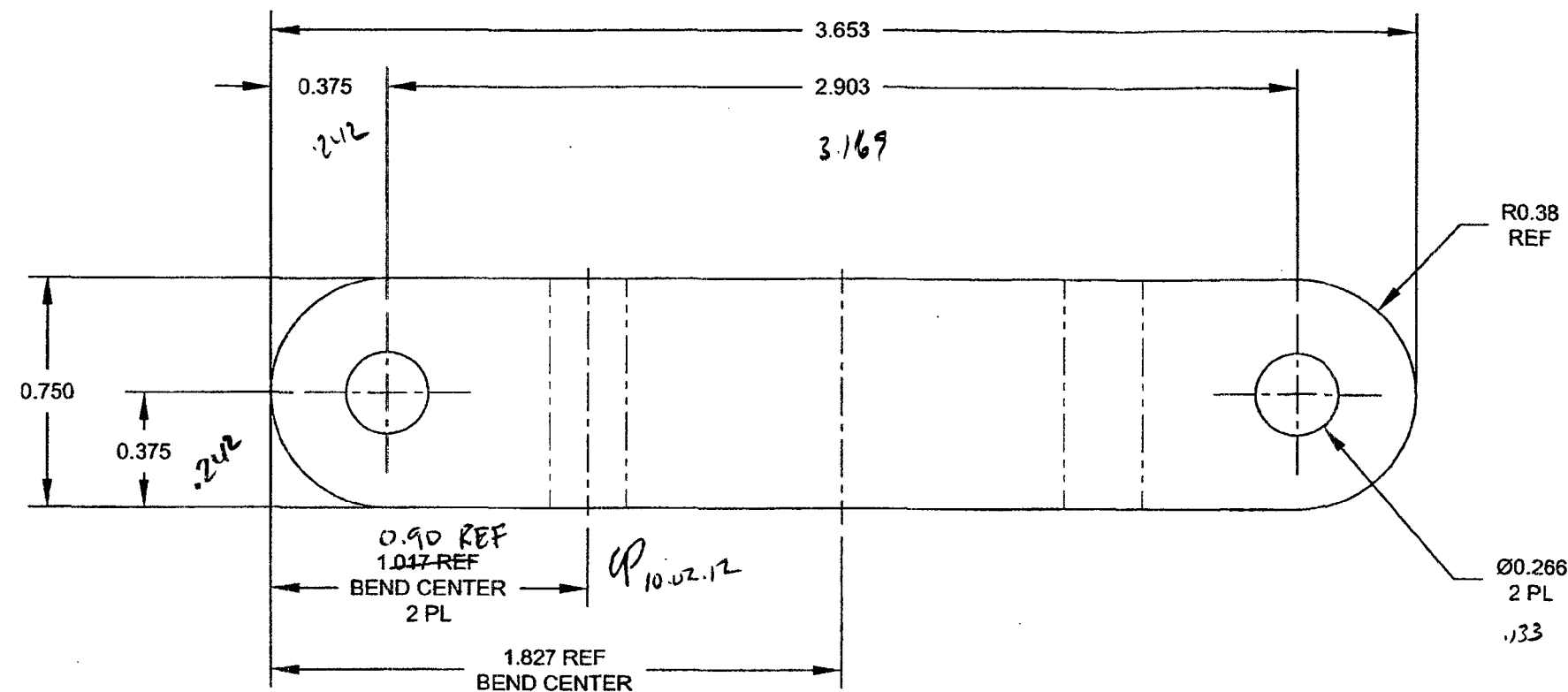
C

B

B

A

A



D4070-1F FLAT PATTERN

W/ 56209

RELEASE
2010-02-16
W/

NOTES:

- 1) MATERIAL: AISI 304/316 SHEET 16 GAUGE (0.063 THICK)
ANNEALED, 2B FINISH
PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D4070	SHEET 3 OF
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	N
DATE	10.02.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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